

Date: Tuesday, 17/02/2009 10:18:51 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 45820		
Estimate Number	: 11403		
P.O. Number	:	Part Number	: D3296041 BK
This Issue	: 17/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3296 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 45271	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/03/2009
Checked & Approved By	: <u>JLD 09-02-17</u>	Qty:	6 Um: Each
Comment	: Est. C 05.10.14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	B 47775

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3	Door Panel	B 420342

3.0	D31617	Hinge 14.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge 14"

Batch: **B 45323****B 455584**

4.0	D31619	Hinge 17.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge 17"

Batch: **B 43314****B 47688**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:51 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 45820

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total : 150.0000 Each(s)

Rivet, Universal Head

Batch: M109631

Ep09/05/26

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

Ep09/05/26 (6)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

501/05/26 (X6)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 2:25pm

OVEN TEMPERATURE: 320°C

FINISH TIME: 2:50pm

21 09-03-27 X6

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd 09/05/27 (6)

10.0 D2137 Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Decal - No Step

Pick:

Qty	Part Number	Description	Batch
1	D2137	Decal	<u>43594</u>

SS 09/05/28 (X6)

11.0 D2419 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Handle

Pick:

Qty	Part Number	Description	Batch
1	D2419	Handle	<u>45639</u>

SS 09/05/28 (X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:51 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 45820

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2462

Seal



Comment: Qty.: 0.3333 f(s)/Unit Total : 1.9998 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 4.00" LONG

D37747

SS 09/05/28 (x6)

13.0

D2462

Seal



Comment: Qty.: 0.4420 f(s)/Unit Total : 2.6520 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 5.30" LONG

B37747

SS 09/05/28 (x6)

14.0

D2462

Seal



Comment: Qty.: 2.0420 f(s)/Unit Total : 12.2520 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 24.50" LONG

B37747

SS 09/05/28 (x6)

15.0

D27281

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

39012

SS 09/05/28 (x6)

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

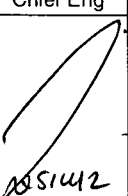

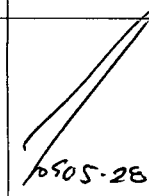
M6085

SS 09/05/28 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3296-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 09/06/03

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>45820</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/04	18.0	upon riveting the fabric handle the rivets pressed cracked. i oversized the hole, rivet is also too long. Q-C: process		Remove & replace qty 3 D3296-3 panel. i 47776 Re-powder coat per w/o i Re-assemble per w/o. i use - 5 rivets for 7.0	FF 09/05/29 41 09/05/29 (23)	S 09/06/01		

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:51 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 45820

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD4-5

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-5 Rivet

M109371

PTO

SS 09105/28 (X6)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

FF 09-06-01 (6)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09106/01 (X6)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST218

SS 09106/02 (X6)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09106/02 (X6)

Job Completion

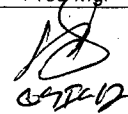
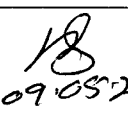


MF 09-06-02

W/O: 45820




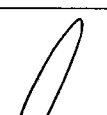

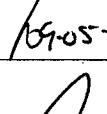
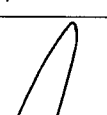
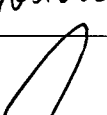
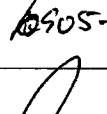
EST: 11403

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/05/28	18	Change MS20470 AD4-6 to MS20470 AD "Permanent Change" ⁴⁻⁵	JH	09/06/02		 09/05/28	 09/05/28

Part No: D3296-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/28	18.0	upon riveting the fabric tag, the rivets were pressed cracked on 3 parts. RC: process.		remove & replace the rivets on the 3 parts. Remove the P-coating on the affected area; fill hole with weld per Q51004 & grind flush Drill open the hole as per dwg, & touch-up areas with plastic per Q51005. Re-powder coat 3 parts black per Q51005. Re-install & carefully the rivets. Ensure the head of the rivet is firmly positioned and slowly press the rivet using multiple presses.	TS 09/05/28			
								
								

NOTE: Date & initial all entries

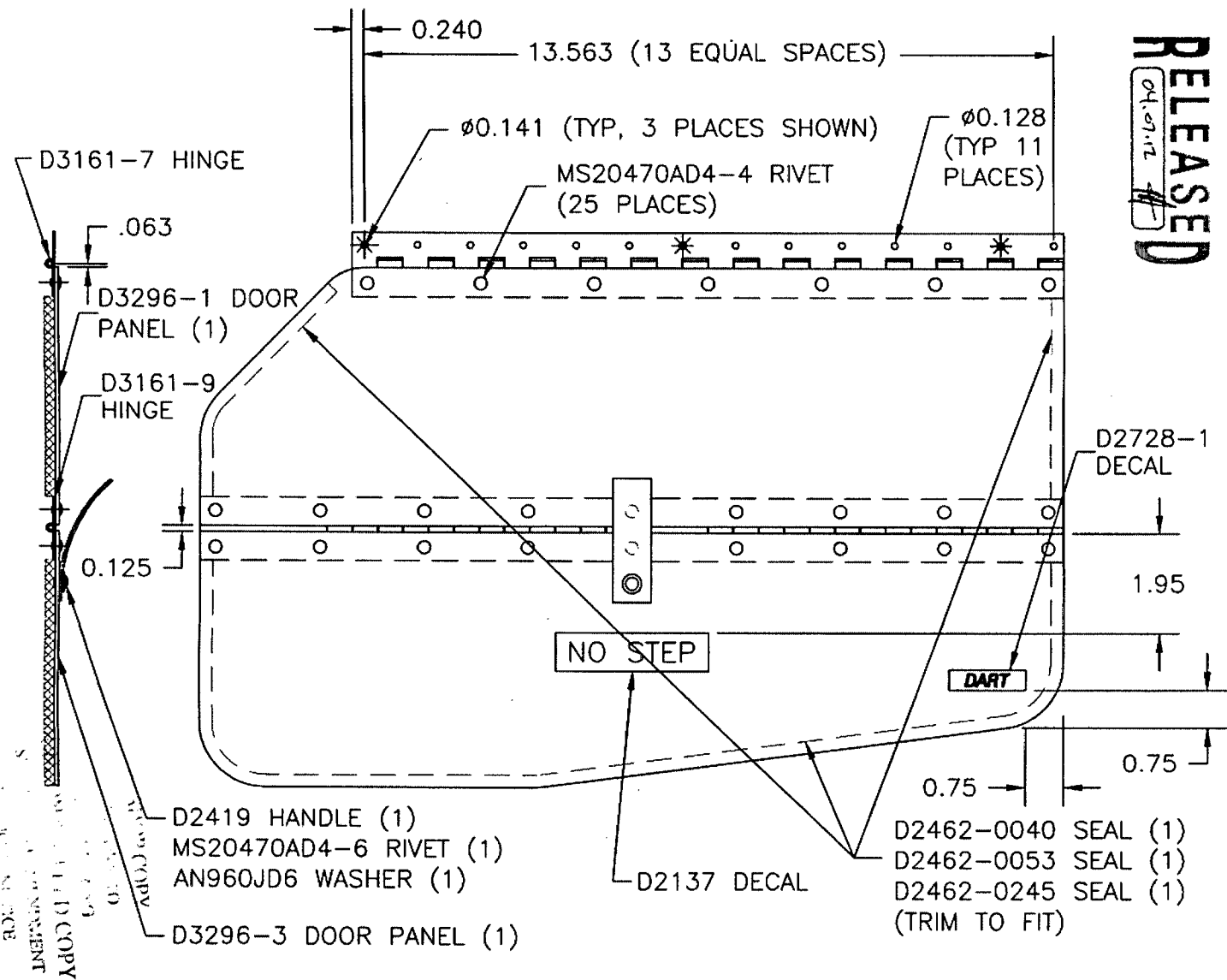
see next page

DART



RELEASED
04.07.12

DESIGN	4/P	DRAWN BY	4/P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO. D3296
DATE	04.06.28	TITLE	DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	NEW ISSUE		SCALE 1:3



D3296-041 DOOR ASSEMBLY

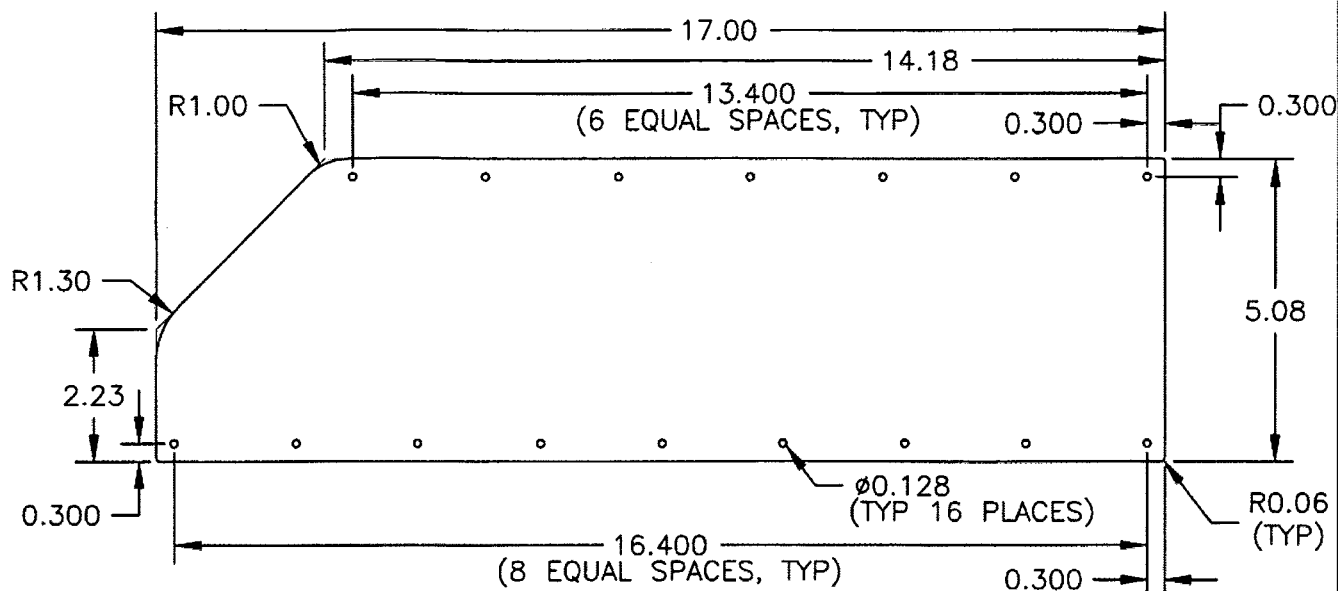
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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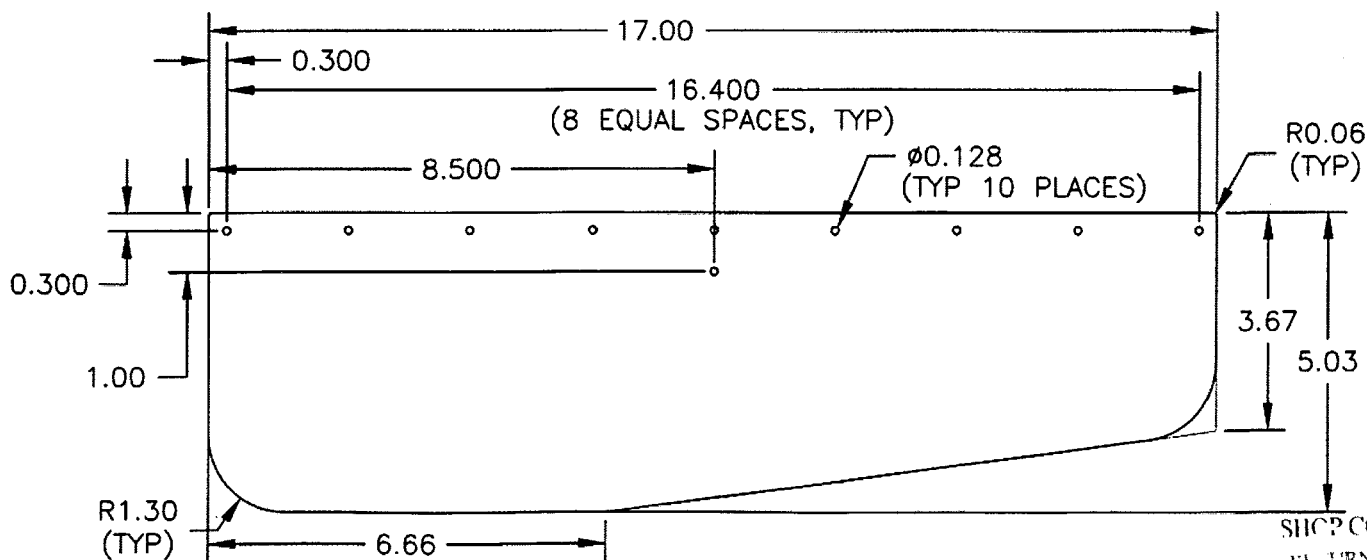
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

NO. 45820

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